

Work Order ID 63377

Page 1

Thursday, October 28, 2010 10:22:23 AM

Item ID: D206-642-541

Accept



Setup Start



Revision ID:

Item Name: Replacement Skidtube

Stop



Start Date: 10/28/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-10-28 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3274	D
IIN-D206-642	Rev M

100

0.00



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP D206-642-541

CHG003

N/A C210112113

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

110

Operation
Description

Skidtubes

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInspec.
Stamp

Skidtubes

Skidtubes

Memo

0.00

****VERIFY AND INSPECT THE MATERIAL PRIOR TO USE****

1- Bend FWD end of tube using bend prog D3274 FWD and foilo 10 as per dwg D3274, cut fwd end of tube with saw table setup D3274.

SAD 10-11-03 ①

2- remove fwd indexing ridge as per dwg D3274. Prepare for welding

BE 10-11-04

3- weld fwd cap as per dwg D3274 and QSI004

AR Aluminum Rod Batch: M111385

BE 10-11-04

4- grind fwd cap weld on top surface only

BE 10-11-04

5- Cut AFT end of tube at 170.9" as per dwg D3274 and deburr end.

6-Drill Aft cap pilot hole using DT8025

7 -Cleco DT8025 in position and install pilot hole drill Jig DT8742A,B,C,D.
Drill 3/16" pilot holes as per Dwg D32748 -Remove inner indexing ridge on aft end of skidtube as per Dwg D3274 scribe
batch #

9 -Open aft end cap holes to Ø0.208" as per Dwg D3274. Deburr aft end.

BB

10/11/09

114 QC 10
116 QC 5

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Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop


**Sequence ID/
Work Center ID**
**Operation
Description**
Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

Chemical Conversion Coat per QSI005 4.1

0.00

1

RR
10/11/09

HandFinish

Hand Finishing

Memo

0.00

130

QC3- Inspect Part Finish

0.00



QC

Quality Control

Memo

0.00

1 Ø BE 10/11/10

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Quality Control

Memo

0.00

N/A
10/11/11

W/O:		WORK ORDER CHANGES						
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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Skidtubes

Skidtubes

Memo

0.00

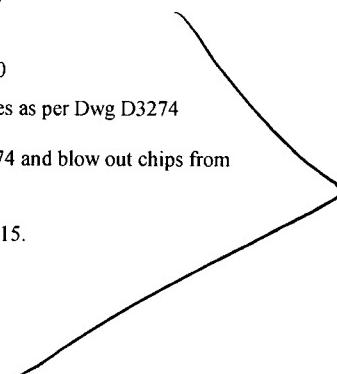
1-Open Ø0.313" and 0.375" crossbolt spacer holes as per Dwg D3274

2-Deburr crossbolt spacer holes as per Dwg D3274 and blow out chips from
inside the tube

3-Bond web in place as per Dwg D3274 & QSI 015.

A/R Sikaflex-291 M116040 Sikaflex expire date: 11-9-30Start: 10-11-11 Time: 11AMFinish: Time:

(Adhere for 12 hours)



10-11-11

160



QC5- Inspect part completeness to step on W/O

0.00

S10/11/16

QC

Quality Control

0.00

(X)

W/O:		WORK ORDER CHANGES					
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Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

0.00

Skidtubes

Memo

0.00

1-Bend AFT end of tube using bend prog. D3274 AFT as per dwg D3274. Install drop pins in crossbolt spacer holes to maintain web position.

BE10/11/16

2- DRILL PILOT HOLES FOR WEARPLATES USING D3274-1T2
OPEN HOLES TO .297". Deburr

3-DRILL TOE PIN HOLE .640" DIA AS PER DWG USING DT8935 FWD

END OF TUBE

DEBURR INSIDE OF HOLE AS NECESSARY (DO NOT ENLARGE HOLES)

REMOVE ANY FOREIGN OBJECTS INSIDE OF TUBES

4- Countersink crossbolt spacer holes as per Dwg D3274

5- prepare for welding



BB

10/11/17

180



QC5- Inspect part completeness to step on W/O

0.00

L = 3.060

Solutions

QC

Quality Control

0.00

L = 4.6°

(76)

W/O #		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

190



Skidtubes

0.00

Skidtubes

Memo

0.00

1-Insert D2649 & D3275-1 crossbolt spacers. Weld as per QSI 004 and Dwg D3274. Remember to back drill each hole before welding the other side. Use aluminum rod

A/R Aluminum Rod
M111385 BE 10/11/22

3-Grind cross bolt welds flush as per Dwg D3274.

4-Counterbore 5/16" x 0.750" deep as per Dwg D3274 and deburr.

3 BE 10/11/22

200



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Solut23

Quality Control

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 11/11/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

210



QC

Quality Control

Operation
Description

QC10- Inspect visual per QSI004- ground welds

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S.101123

(70)

220



HandFinish

Hand Finishing

Pressure Wash per QSI005 4.3

0.00

=) M 101123

1 J

Memo

0.00

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch

230



Powdercoat

Powder Coating

White Gloss(Ref.4.3.5.1) per QSI005 4.3-Alum

0.00

M115851

8:25

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320

8:55

1 10-11-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center ID

240



QC

Quality Control

Operation
Description

QC3- Inspect Part Finish

Set Up/
Run Hours

0.00

0.00

Tool ID

1011129

Tool #

1011129

Plan
Code

1011129

Accept
Qty

1

Reject
Qty

0

Reject
Number

1

Insp.
Stamp

10/11/29

250



HandFinish

Hand Finishing

HandFinishing

0.00

=) 1011129

Tool ID

1011129

Tool #

1011129

Plan
Code

1011129

Accept
Qty

1

Reject
Qty

0

Reject
Number

1

Insp.
Stamp

10/11/29

260



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

Inspect Nut Plate & Inserts

MW 10 11 29 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 63377

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Thursday, October 28, 2010 10:22:23 AM

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Revision ID:

Item Name: Replacement Skidtube

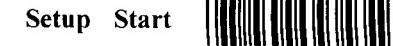
Start Date: 10/28/2010 Start Qty: 1.00

Required Date: 11/11/2010 Req'd Qty: 1.00

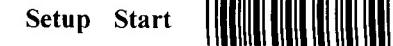
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Approvals:

Process Plan: _____ Date: _____ Tooling: _____ Date: _____

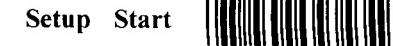
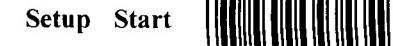


QC: _____ Date: _____ SPC (Y/N): _____ Date: _____



Cust Item ID:

Customer:

Sequence ID/
Work Center ID

270



HandFinish

Hand Finishing

Operation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

JH

10/12/09

1

0

HAND FINISHING RESOURCE #1

Memo

0.00

✓ 1-Install wearpads & gaskets as per Dwg D3274.

✓ 2-Install ring as per Dwg D3274
A/R Sikaflex-291 11/15/14
Sikaflex expire date: 11/10/14

✓ 3-Inspect for foreign objects as per QSI 024

✓ 4-Spray inside of tube on both sides of web with LPS-3
A/R LPS-3 Batch: N/A✓ 5-Install Aft Cap and seal with Sikaflex. Clean excess adhesive.
A/R Sikaflex-291 11/15/14
Sikaflex expire date: 11/10/14

280



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

10/12/09

W/O:		WORK ORDER CHANGES					
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Reference:

Approvals: Process Plan: _____

Date: _____ Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

290



Packaging

Packaging

Operation
Description

Identify as per dwg & Stock Location: _____

Set Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

PNP 63381 0.00

300



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

 10-12-13
 MF
 10-12-16

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
IPP Rev:C 07-02-23 Added SS Wearplates & Gaskets JLM
IPP Rev:D 07-12-06 replace NAS1515H3L to D3672-1 DD
IPP Rev:E 08-04-17 as per PAR 08-015 DD verified by:EC
IPP Rev:F 08-06-02 add comment DD verified by:EC
IPP Rev:G 08-10-09 revise details DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-1-190		Manufactured	No			110	Each	63.0000	1	1		SAD	10-11-03

Extrusion Round 3" 206



Location	Loc Qty	Loc Code
LG	63	
47575	15	
59874	48	

D3285-1



Manufactured

No

110

Each

141.0000



1

Cap

Location	Loc Qty	Loc Code
LG	141	
52511	74	
52647	67	

D3282-041



Manufactured

No

150

Each

0.0000



1

Float Web (206L/407)

B60931

10-11-04
DP 10-11-11

W/O:		WORK ORDER CHANGES					
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Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D2649



Manufactured No

190

Each

107.0000

12

12



Cross Bolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	107	
58545	2	
60652	4	
61496	13	
62889	88	

8-63359 12 660/11/22

D3275-1



Manufactured No

190

Each

216.0000

12

12



Crossbolt Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
LG	216	
53453	8	
61646	102	
62399	106	

BE 10/11/22

CR3212-4-03



Purchased No

250

Each

1,874.000

2



Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST311	1874	
111359	5	
112314	2	
114436	448	
114450	71	XZ
114859	1348	

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Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3415-041



Manufactured

No

250

Each

52.0000

1

1

ll
1011129

Nut Plate

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST056	52	
-------	----	--

33842

	52	
--	----	--

CCR264SS3-3



Purchased

No

250

Each

416.0000

2

x1
2
ll
1011129

Cherry Rivet

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST311	416	
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112314

	4	
--	---	--

113539

	44	
--	----	--

113973

	368	
--	-----	--

ALS4-1032-130



Purchased

No

250

Each

2,653.000

78

ll
78
1011112

Insert

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

PKG11	886	
-------	-----	--

114723

	886	
--	-----	--

11116 049

x78

ST282	1728	
-------	------	--

110511

	10	
--	----	--

115911

	1718	
--	------	--

ST381	39	
-------	----	--

114654

	39	
--	----	--

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 4

Work Order ID: 63377



9

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3536-15



Manufactured No

270

Each

18.0000

1

1



Mel 10/12/09

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	6	B63568
56055	1	
60875	5	
FP11	12	
59238	1	
62459	11	

D3536-23



Manufactured No

270

Each

3.0000

1

1



Mel 10/12/09

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP011	3	B63238
61237	3	

D3536-35



Manufactured No

270

Each

16.0000

1

1



Mel 10/12/09

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP012	16	B63579
58683	1	
61692	3	
62462	12	

D3536-39



Manufactured No

270

Each

12.0000

1

1



Mel 10/12/09

Gasket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP12	12	B63578
58215	1	
58571	11	

x1

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 5

Work Order ID: 63377



01

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-15



Manufactured No

270

Each

22.0000

1

1



M 10/12/09

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	22	B63569
61241	6	
62241	3	
62707	13	

D3535-35



Manufactured No

270

Each

26.0000

1

1



M 10/12/09

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP018	26	
60865	6	
62461	12	
<u>62969</u>	8	

D3535-39



Manufactured No

270

Each

27.0000

1

1



M 10/12/09

Wearshoe

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP18	27	
60233	16	
<u>62945</u>	11	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 6

Work Order ID: 63377



9

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3535-23



Manufactured No

270

Each

28.0000

1

1



Wearshoe

M 10/10/2010

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	7	
61830	6	
FP021	21	
60231	8	
<u>62706</u>	13	

D3537-3



Manufactured No

270

Each

40.0000

1

1



Wearpad

M 10/10/2010

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP17	40	
60866	3	
61674	17	
<u>62705</u>	20	

D3537-1



Manufactured No

270

Each

66.0000

9

9



Wearpad

M 10/10/2010

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP	1	B63545
55465	1	
FP017	59	
61986	15	
62209	44	
FP17	6	
57713	3	
60491	3	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 7

Work Order ID: 63377



9

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN960C10L

NAS1149C0332

Purchased

No

270

Each

29.0000

80

80

washer



M 10/12/09

AN960C416

NAS1149C0463

Purchased

No

ST245

Loc Qty

Loc Code

107534

29

X1115832

29

X80

washer



M 10/12/09

D3672-1



Manufactured

No

ST346

Loc Qty

Loc Code

100993

30

X1115358

30

X1

Phenolic Washer

ST077

Loc Qty

Loc Code

42329

847

52505

150

697

X2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:32 AM

Page 8

Work Order ID: 63377



9

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

AN3C4A



Purchased

No

270

Each

2,233.000

80

80



10112109

BOLT

Location	Loc Qty	Loc Code
ST303	3	
115438	3	
ST350	2230	
114108	14	
114416	12	
114523	2	
115300	202	
115589	1000	
<u>115936</u>	1000	

x80

AN4C5A



Purchased

No

270

Each

481.0000

1



1

10112109

BOLT

Location	Loc Qty	Loc Code
ST346	481	
110552	4	
<u>112243</u>	477	

x1

D2646



Manufactured

No

270

Each

45.0000

1



1

10112109

Aft Cap

Location	Loc Qty	Loc Code
FP-4	35	
<u>57332</u>	35	
fp5	6	
62652	6	
FP6	4	
52663	4	

x1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Thursday, October 28, 2010 10:22:33 AM

Page 9

Work Order ID: 63377



✓ 9

Parent Item: D206-642-541



Parent Item Name: Replacement Skidtube

Start Date: 10/28/2010

Required Date: 11/11/2010

Start Qty: 1.00

Required Qty: 1.00

D3413-1



Manufactured No

270

Each

23.0000

1

1



Ring

10/12/109

Location

ST473

Loc Qty

23

Loc Code

B6Z961

X1

51586

1

53446

7

61322

15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN CP	DRAWN BY PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA
CHECKED #	APPROVED #	DRAWING NO. D3274
DATE 06.12.19		REV. D SHEET 1 OF 4
		TITLE SKIDTUBE ASSEMBLY
		SCALE NTS
A	04.03.15	NEW ISSUE
B	04.08.09	MOVE SADDLE HOLE: 42.14 WAS 42.76
C	05.03.16	ADD -043; NEW INSERTS
D	06.12.19	NEW INSERTS, SS WEARSHOE + GASKET

RELEASED07.02.12 **#****DEO ATTACHED****SHOP COPY**RETURN TO
ENGINEERING**UNCONTROLLED COPY**

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. **63377****PH-10-28**

Qty -041	Qty -043	Part Number	Description
X		D3274-041	SKIDTUBE ASSEMBLY
	X	D3274-043	SKIDTUBE ASSEMBLY
1	1	D2600-1-240	EXTRUSION
1	1	D2646	AFT CAP
12	12	D2649	CROSS BOLT SPACER
12	37	D3275-1	CROSS BOLT SPACER
1	1	D3282-041	FLOAT WEB
1	1	D3285-1	CAP
1	1	D3413-1	RING
1	1	D3415-041	NUT PLATE
1	1	D3535-15	WEARSHOE
1	1	D3535-23	WEARSHOE
1	1	D3535-35	WEARSHOE
1	1	D3535-39	WEARSHOE
1	1	D3536-15	GASKET
1	1	D3536-23	GASKET
1	1	D3536-35	GASKET
1	1	D3536-39	GASKET
9	9	D3537-1	WEARPAD
1	1	D3537-3	WEARPAD
78	78	ALS7-1032-130	INSERT (or AKS4-1032-130, ALS4-1032-130, AELS-1032-130)
80	80	AN3C4A	BOLT
1	1	AN4C5A	BOLT
1	1	AN960C416	WASHER
80	80	AN960C10L	WASHER
2	2	CCR264SS3-3	RIVET
2	2	CR3212-4-03	RIVET
2	2	NAS1515H3L	WASHER

GENERAL NOTES:

1. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
2. DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 7 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
3. ALL HOLES DRILLED ON CENTERLINES.
4. BOND D3282-041 FLOAT WEB INTO D3274-1/3 OUTER TUBE WITH NON-STRUCTURAL SIKAFLEx-241/291 ADHESIVE PER DART QSI 015. ENSURE HOLES LINE-UP.
5. WELDING TO BE DONE PER DART QSI 004.
6. FINISH: - ACID ETCH, ALODINE ASSEMBLY PER DART QSI 005 4.1
- POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
7. DRILL Ø0.297 HOLES FOR ALS7-1032-130 INSERTS USING DT3274-1T2 BEFORE FINISH. INSTALL ALS7-1032-130 INSERTS AFTER FINISH. SEAL WEARSHOE BOLTS WITH SIKAFLEx-241/291.
8. SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND INSTALLATION OF INSERTS. COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF POWDER COATING WITH MEK DEGREASER.

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

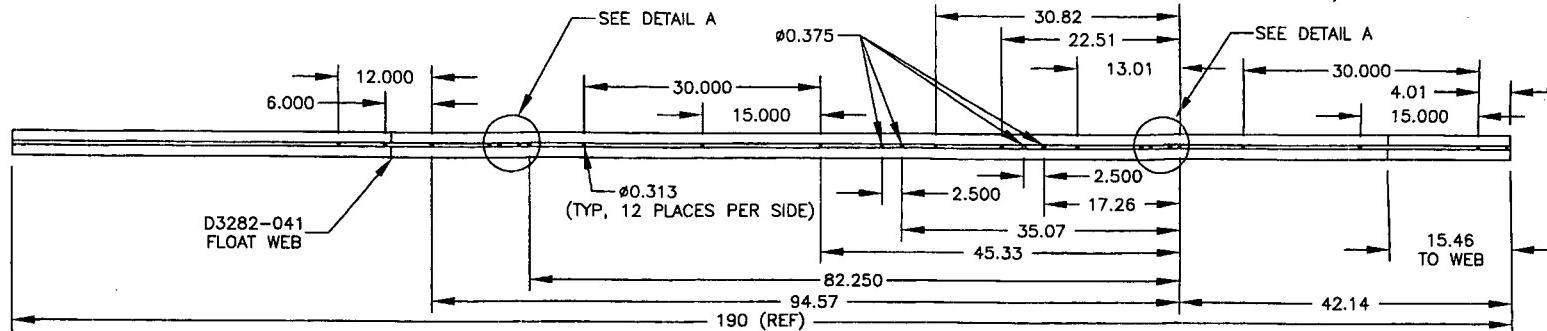
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

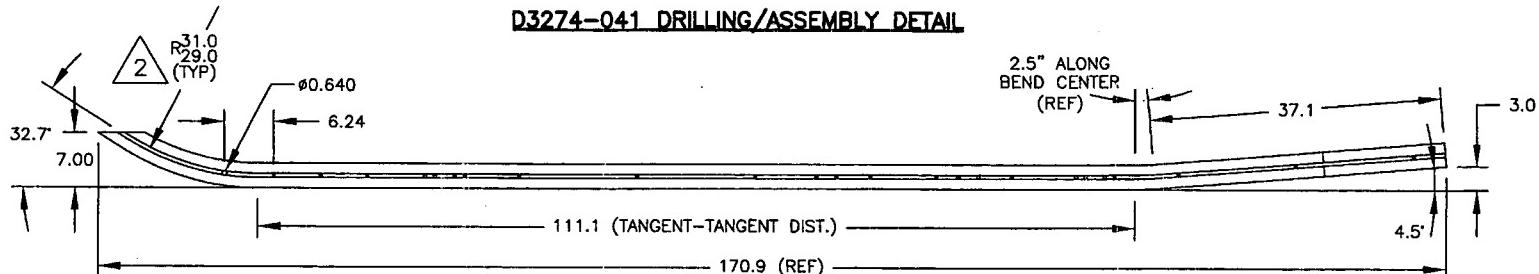
NOTE: Date & initial all entries

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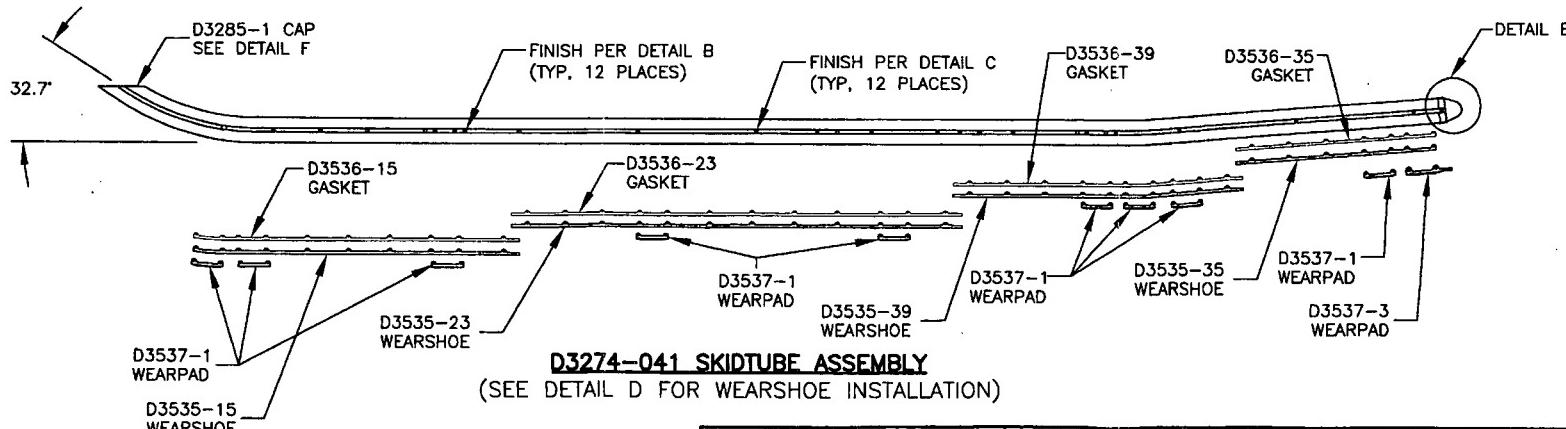
WB 13377



D3274-041 DRILLING/ASSEMBLY DETAIL



D3274-041 BEND/DRILLING DETAIL



D3274-041 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

DESIGN	DRAWN BY	DART DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CP	RH		
CHECKED	APPROVED	DRAWING NO.	REV. D
		D3274	SHEET 2 OF 4
DATE	TITLE	SCALE	
06.12.19	SKIDTUBE ASSEMBLY	1:15	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

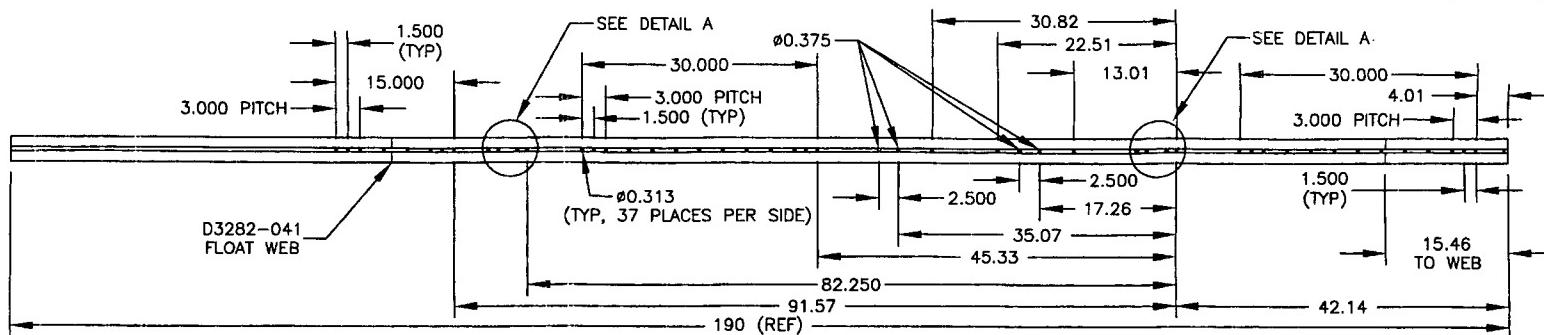
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

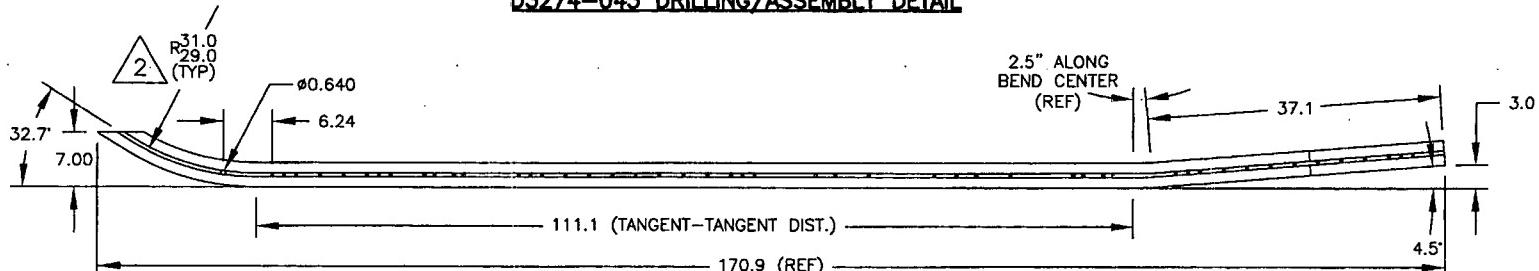
NOTE: Date & initial all entries

wlo 43377

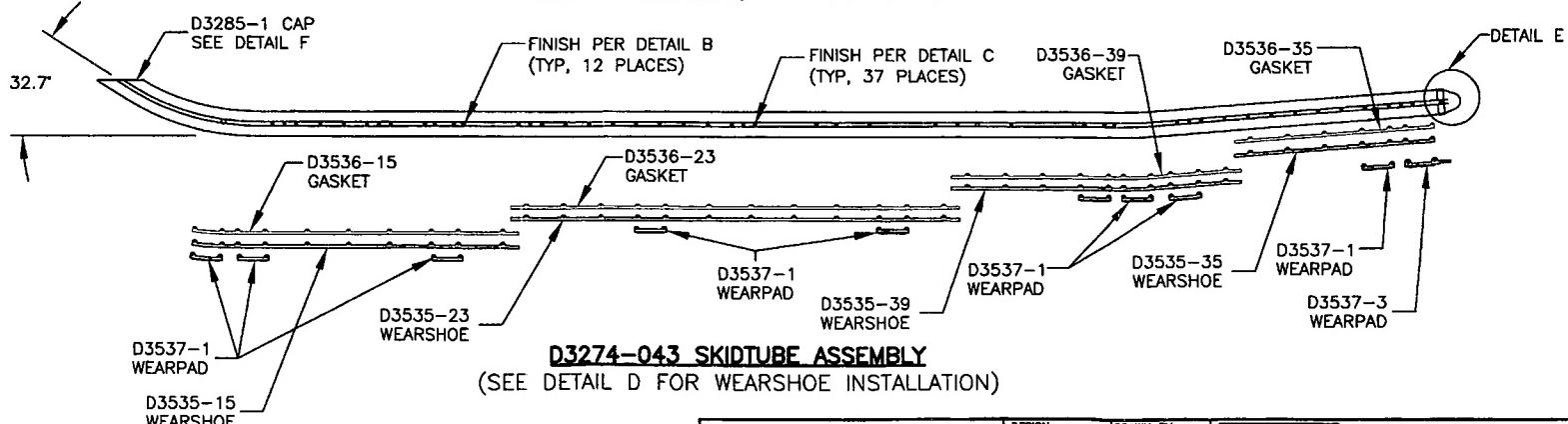
DEO ATTACHED



D3274-043 DRILLING/ASSEMBLY DETAIL



D3274-043 BEND/DRILLING DETAIL



D3274-043 SKIDTUBE ASSEMBLY
(SEE DETAIL D FOR WEARSHOE INSTALLATION)

RELEASED

07.02.12

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THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED OR COPIED IN ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	CHECKED #	APPROVED #	DRAWING NO.	REV. D
			D3274	SHEET 3 OF 4
DATE	TITLE	SCALE		
06.12.19	SKIDTUBE ASSEMBLY	1:16		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

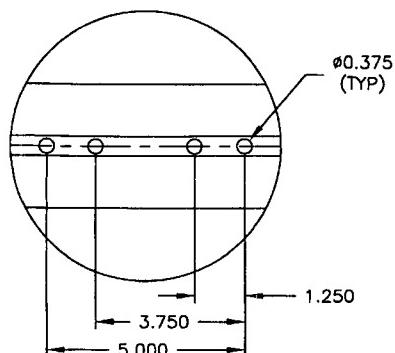
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

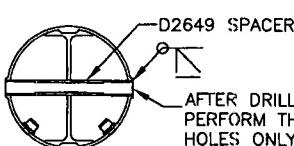
NOTE: Date & initial all entries

W/C 03377

DETAIL A: DRILL DETAIL

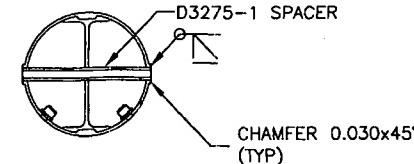


DETAIL B
FOR Ø0.375 HOLES ONLY



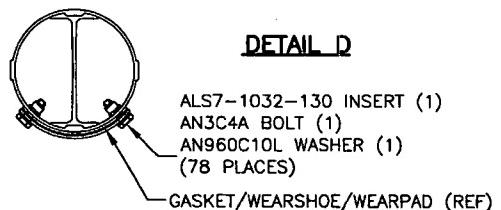
AFTER DRILLING AND BENDING ASSEMBLY
PERFORM THE FOLLOWING FOR Ø0.375
HOLES ONLY:
1. CHAMFER HOLE 0.030x45°
2. INSERT D2649 SPACER
3. WELD INTO PLACE AND GRIND FLUSH
4. C'BORE TO Ø0.313x0.75 DEEP

DETAIL C
FOR Ø0.313 HOLES ONLY



CHAMFER 0.030x45°
(TYP)

DETAIL D

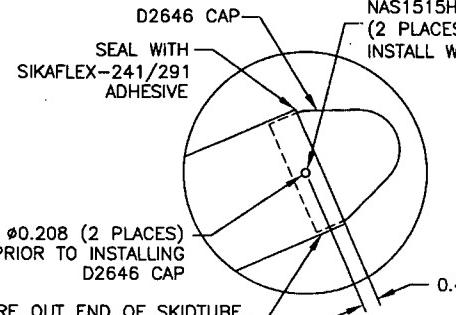


ALS7-1032-130 INSERT (1)
AN3C4A BOLT (1)
AN960C10L WASHER (1)
(78 PLACES)
GASKET/WEARSHOE/WEARPAD (REF)

DETAIL E AN3C4A BOLT (1)

AN960C10L WASHER (1)
NAS1515H3L WASHER (1)
(2 PLACES)

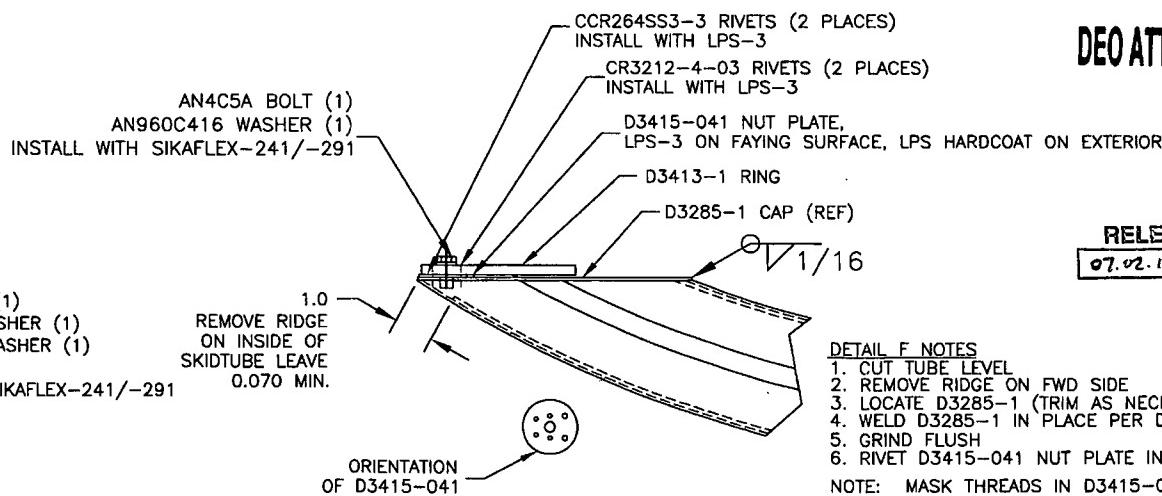
INSTALL WITH SIKAFLEX-241/-291



Ø0.208 (2 PLACES)
DRILL PRIOR TO INSTALLING
D2646 CAP

BORE OUT END OF SKIDTUBE
TO 0.75 DEPTH AND 0.070 WALL

DETAIL F: END FINISHING DETAIL



REMOVE RIDGE
ON INSIDE OF
SKIDTUBE LEAVE
0.070 MIN.

ORIENTATION
OF D3415-041

DET ATTACHED

RELEASED

07.02.12 *H*

DETAIL F NOTES

- CUT TUBE LEVEL
- REMOVE RIDGE ON FWD SIDE
- LOCATE D3285-1 (TRIM AS NECESSARY)
- WELD D3285-1 IN PLACE PER DART QSI 004
- GRIND FLUSH
- RIVET D3415-041 NUT PLATE IN PLACE

NOTE: MASK THREADS IN D3415-041
PRIOR TO FINISH

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DESIGN

CP

/

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PH

/

DART

DART AEROSPACE USA, INC.
PORT HUENEMER, MA

REV. D

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1/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DRAWING NO. D3274	TITLE SKIDTUBE ASSEMBLY	REV. D	DART AEROSPACE USA, INC ENGINEERING ORDER	D.E.O. NO. D3274-D-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN <i>CP</i>	CHECKED	MFG. APPR. <i>M</i>	APPROVED	<i>MAP</i>	DE APPR. <i>#</i>	
DATE 09.06.17	DATE 09.06.23	DATE 09/06/23	DATE	09/06/23	DATE 09.06.23	

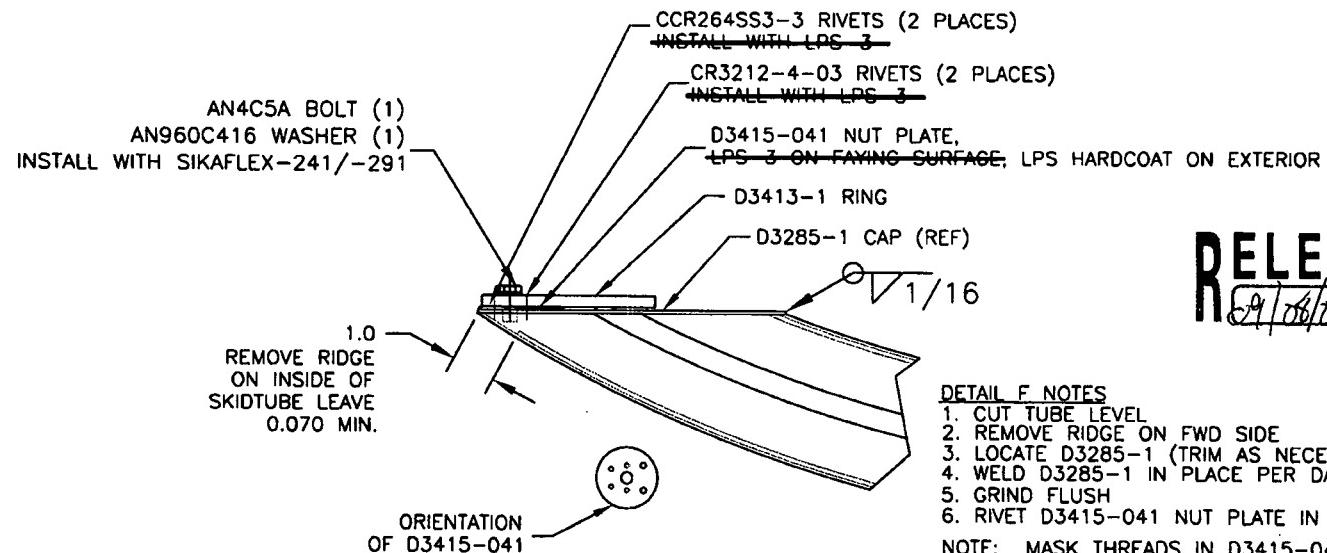
LPS-3 IS NO LONGER USED DURING ASSEMBLY OF SKIDTUBE.

AMEND NOTE 8: "~~SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES 'LPS-3' AFTER FINISH AND INSTALLATION OF INSERTS.~~
~~COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES 'LPS PROCYON' AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF~~
~~POWDER COATING WITH MEK DEGREASER."~~"

AMEND DETAIL F AS SHOWN:

w/o 43377

DETAIL F: END FINISHING DETAIL



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

NO. 241

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliott
Job number: 622508
Part number: D906 642 - 541
Description: 206 skid
Welding Process: Tig[] Mig[]
Base material: Aluminum
Current: AC[] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[] fail[]
Penetration: pass[] fail[]

UNACCEPTABLE

Cracks: pass[] fail[]
Undercut: pass[] fail[]
Pin holes: pass[] fail[]
Overlap (cold lap) pass[] fail[]
Porosity (surface): pass[] fail[]
Coloration: pass[] fail[]

Qualifier R.D. Date of Test Coupon 10-09-30
Welder Barclay Elliott Date of Test Coupon 10-09-30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld.